Work Order II June-24-13 2:00:14 P			*103	3653*						Page 1
Item ID: D223 Revision ID:	2-3 🛭 🙎 2 3 2 - 3	·	Accept	*N900	040	100)* s	etup Stai	rt *N	S1*
	t Hinge							Sto	^P *N	S2*
Start Date: 6/24/3 Required Date: 7/05/3 Reference:				Cust Item Customer:						
	cess Plan: <u>ML</u> ゴ	Date: 13 06-25	Tooling: _	D)ate:		R	kun Stai Sto		R1*
QC:		Date:	SPC (Y/N):	D	ate:				" *N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D2232	Rev C									
100	FLOW WATER JET		0.00				13	6		In 1309-16
Waterjet	Memo		0.00				10			
FLOW CNC Waterjet	1-Cut as p Deburt if	per Dwg D2232 Dwg Rev:_ necessary	Prog Rev: C	2-				,		
110	QC2-Inspect parts of	f machine FAI/FAIB	0.00							
110 QC Quality Control	Memo		0.00				19	0		Jm3-09-16
120	QC8- Inspect parts - s	econd check	0.00 DAS 27				\sim			
120 QC Quality Control	Мето		0.00 13 9	. 16			12			

DQA: Date:					WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / U		Work Order u	ndata anly - [AEROSPACE			
QA Closed.		Date.					I			Work Order up	date only				
Work Order	r:				DISPOSITION				AGAINST D	PEPARTMENT	/PROCESS				
					Rework			Skid-tube	Crosstube		Water Jet	Engineering			
Part No	o				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
					Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other			
NCR No	0				Suspected Unapproved]		Large Fab	Composite		Supplier				
Root				Desci	ription of work order update		Initial	Ac	tion	Sign &					
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector			
Design							· · · · · ·								
Doc/Data		•													
Equip/Tooling		ĺ		ſ		ŀ									
Handling/Pre		į													
Material															
Operator						ŀ									
Offset/Setup															
Process															
Supplier								:							
Training		į									-				
Transport															
Unapproved		ļ													
	<u> </u>	··				FAI	ULT CAT	regory							
Landing	g Gear		_		General		_				_	_			
_	Bending				Bend		Folio/P	rogram	Į_	Outside Dim	ensions	Pressure/Forced			
	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up			
1_	Cracks				Broken/Damage/Defect		Hardwa	re]	Part Incorred	ct	Temperature/Cure			
_	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/Mi	ssing	Weld			
L	Cuffs				Contamination		1	ions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled			
	Crushing				Countersink	<u> </u>	4 ~	ned/off center		Positioned V	/rong	 -			
	Heat Trea				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other			
L	Inspection	· .	Tube		Drawing		Misread	1							
	Marks/Ch				Drill Holes		Off-set								
	Turning S	equence			Finish		Out of 0	Calibration							
Wave/Twist in Tube			1	Fit/Function		Out of s	Sequence		-						

	Work Orde June-24-13 2:00		3653		*103				Page 2			
	Revision ID:	D2232-3 Basket Hinge			Accept	*N900	<u>040</u>	100)* s	Setup Star	I VI	S1* S2*
٠.	Start Date: Required Date: Reference:	6/24/13 7/05/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item 1 Customer:	D:					; ;
	Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		F	Run Sta Sto	" \	R1* R2*
	Sequence ID/ Work Center II 130 *120* Small Fab Small Fab)	Operation Description Small Fab Mano Debut		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	*140 *140* Packaging Packaging		Identify as per dwg & Stoo Memo *****STOCK	ck Location: NACO	0.00				_12×_	128 28	13	-09-16
	150		QC21- Final Inspection -	Work Order Release	0.00							÷.

0.00

Memo

Quality Control

MLJ 13-09-17

DQA:		Date:										***	► A DT
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UP		(aul. Ondau			AEROSPACE
QA Closed.		Date.					<u> </u>		VV	ork Order up	date only	<u> </u>	
Work Orde	er:				DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS		
	•				Rework	1		Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	No.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.		Quality
					Use-as-is	1	Therr	moforming	Finishing	Rec/Sto	re/Packaging		Other
NCR N	No				Suspected Unapproved]		Large Fab	Composite]	Supplier		
Root				Desci	ription of work order update		Initial	Actio	on	Sign &		T	
Cause	Date	Step	Qty		or non-conformance	Cł	nief Eng	Descri	ption	Date	Verificatio	n	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport		100											
Unapproved	<u> </u>	• 1				<u> </u>							
		5.8e '				FA	ULT CA	TEGORY					
Landi	ng Gear				General		7			7			
	Bendin	-			Bend	_	1	Program	_	Outside Dim	ensions	∐ Pr	ressure/Forced
		Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	∐ S∈	et-up
	Cracks				Broken/Damage/Defect		Hardwa			Part Incorred		ŬŢ€	emperature/Cure
		Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unc	qualified	Part Lost/Mi	ssing	Шw	'eld
	Cuffs				Contamination		4	tions Incomplete/Ur	nclear	Part Moved		∐w	rong Stock Pulled
	Crushin	_			Countersink		1	gned/off center		Positioned V	- 1		
	Heat Tr				Cut Too Short		Mislabe		L	Power Loss/	Surge	0	ther
	lacksquare	ion Strip in	Tube		Drawing		Misread						
		Chatter			Drill Holes		Off-set				·		
	—	Sequence			Finish		4	Calibration					
	Wave/Twist in Tube		Fit/Function	1	Out of	Sequence							

June-24-13 2:00:13 PM

Work Order ID:

103653

Parent Item:

D2232-3

Parent Item Name:

Basket Hinge

Start Date: 6/24/13

Required Date: 7/05/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP B01.06.07Now laser cutEC

IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seg ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet	•	Purchased	No			100	sf	322.5833	0.0694	_0.8766312 . O		ブ	MB-09-16
				Location		Loc Oty	L	oc Code					
	A contract			MAT020_		322.5832632							

322.5832632 122521 19.1432632 124445 111.44 M126075 192

24445

DQA:			. Date:			- ΔART										
						WORK ORDER NON	-C(ONFO	RMANCE / U			_	AEROSPACE			
QA Closed:	_		Date:					•		. V	/ork Order up	odate only				
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS				
	-			*****		Rework			Skid-tube	Crosstube	7	Water Jet	Engineering			
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
	' <u></u> .					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other			
NCR N	No					Suspected Unapproved			Large Fab	Composite		Supplier				
Root					Desc	ription of work order update	i	Initial	Ac	ction	Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	QC Inspector			
Design																
Doc/Data																
Equip/Tooling	Ш															
Handling/Pre				`		•										
Material	Ш															
Operator									*							
Offset/Setup																
Process			,													
Supplier																
Training	Ш												-			
Transport	Ш															
Unapproved																
<u> </u>							FAI	ULT CAT	EGORY							
Landi	ng Ge	ear				General					_	<u>.</u>				
	∐ ^E	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced			
	Щ	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up			
	\Box	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	it _	Temperature/Cure			
	\Box	Crimp/Kin	k/Ripple	/Wave		Burrs		Inspecti	on Incomplete/U	Inqualified	Part Lost/Mi	ssing	Weld			
		Cuffs				Contamination		Instruct	ions Incomplete/	'Unclear	Part Moved		Wrong Stock Pulled			
		Crushing				Countersink		Misalig	ned/off center		Positioned V		_			
	╝	Heat Trea	t			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other			
		nspection	n Strip in	Tube		Drawing		Misread	I							
		Marks/Ch	atter			Drill Holes		Off-set								
	Щт	Turning S	equence			Finish	Out of Calibration									
	Wave/Twist in Tube				Fit/Function	Out of Sequence										

DART AEROSPACE LTD	Work Order:	103653
Description: Basket Hinge	Part Number:	D2232-3
Inspection Dwg: D2232 Rev: C		Page 1 of 1

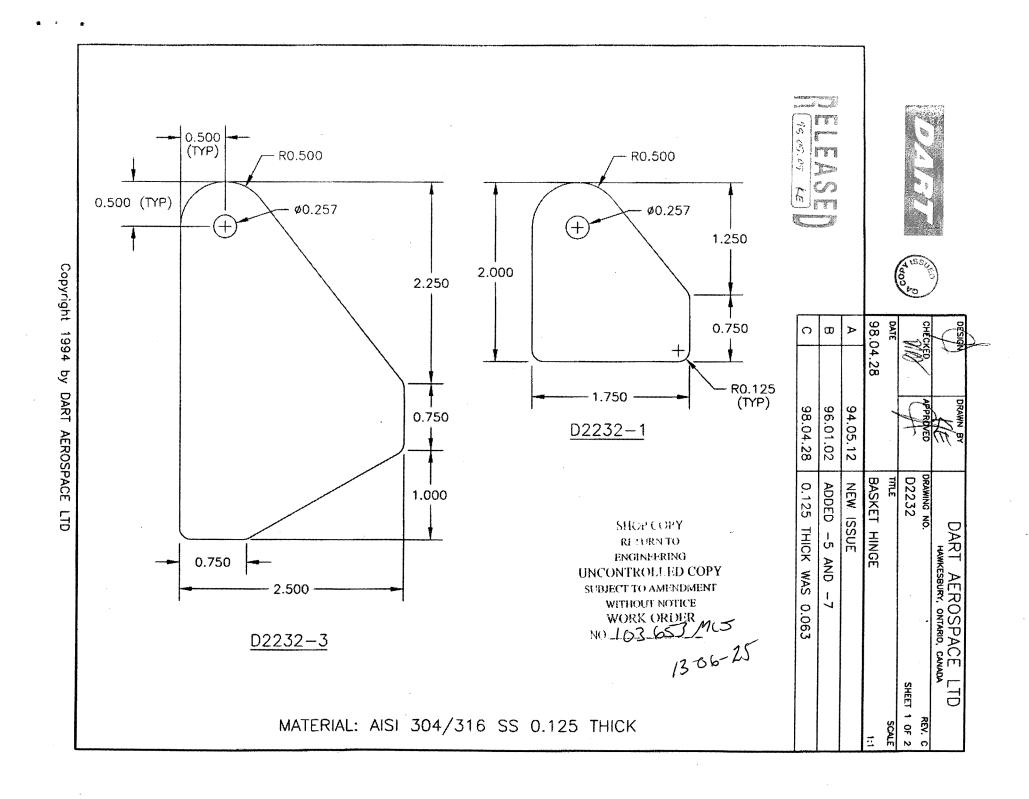
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.503	•	3444	V	Thmor
0.750	+/-0.010	0.7500	-		V	
2.500	+/-0.010	2.505	-		V	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,
1.000	+/-0.010	1.000)		V	
0.750	+/-0.010	0.750"	_		2	
2.250	+/-0.010	2.250	-		V	
0.500	+/-0.010	0.505	_		V	
Ø0.257	+0.006/-0.001	0.258-			V	
	-					
				· [
			DAS			

		27		
Measured by: 3m	Audited by:	9-89	Prototype Approval:	N/A
Date: 13-09-16	Date:	13 9 16	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.11.08	New Issue	KJ/JLM	R



DQA:		_ Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / U		ork Order up	date only	_	AEROSPACE		
Work Orde	or.				DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS				
Part N	lo				Rework Scrap Use-as-is Suspected Unapproved		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	={	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other		
Root				Desci	ription of work order update	Π	Initial	Ac	ction	Sign &					
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	ı	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport															
						FAI	ULT CAT	EGORY			· · · · · · · · · · · · · · · · · · ·				
Landin	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Instruct Misalig Mislabe Misread Off-set	re on Incomplete/U ions Incomplete/ ned/off center led	'Unclear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/S	tolerance et ssing /rong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
Turning Sequence Wave/Twist in Tube				Fit/Function	Out of Calibration Out of Sequence										





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED /	APPROVED	DRAWING NO.	REV. C
MM	IA	02232	SHEET 2 OF 2
DATE	•••	TITLE	SCALE
 98.04.28		BASKET HINGE	1:1

